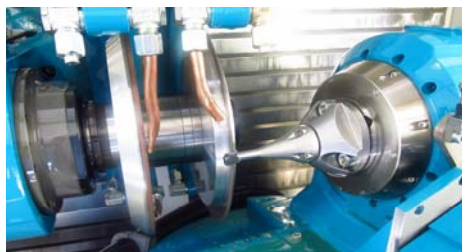













## Insert 2-Sided Ø23 Z2

A08-200

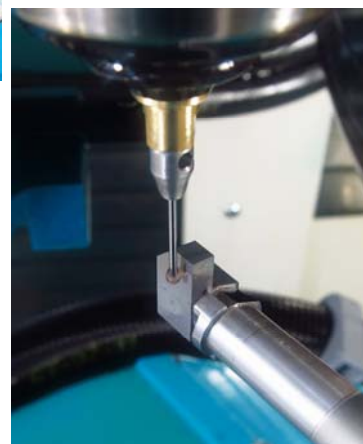
This special insert is ground in one setup from a blank, on which the front- and backface are preground. After probing the orientation and excentricity, the references sides are ground using a cup wheel and oscillation movements - as well for the 8 mm thickness and 10 mm reference of 20 degrees. The profile is ground with a pregrinding and finishing operation. In the same setup the oblique chipbreaker is also ground.



### 1. Cycletime for Production

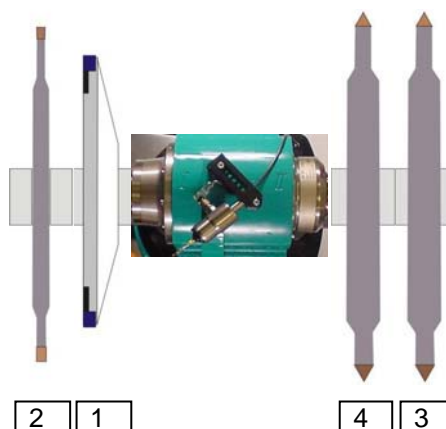
Workpiece: special blank 8x8x23 Material CARBIDE						
Operations						
Feed [mm/Min]	2000	5000	5000	1800	20	50
Power [kW]		1	1	1	1	1
Cutting speed [m/s]		22	22	22	20	22
Used wheels						
Grinding time [s]	20	37	41	45	174	100
Total cycle time	6 Min 56					

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.



### 2. Used Grinding Wheels

1	12C9 Ø250 D64
2	14A1 Ø250 D64
3	14V1 Ø300 D64V40°
4	14V1 Ø300 D46V40°



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 310i

Software: Quinto 5

Accessories: TTC Clamping, Robot

Responsible engineer: OP, 27.12.11

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